

Work Order ID 108991

October-31-13 1:38:48 PM

108991

Page 1

Item ID: D3694-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Mounting Plate

Start Date: 10/30/13 Start Qty: 5.00

5

Cust Item ID:

Required Date: 10/30/13 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: MCS

Date: 13-10-31 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
----------	--------------

D3694	Rev C
-------	-------

100		0.00							
-----	--	------	--	--	--	--	--	--	--

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 7.150" long

5 0 13-11-08

110		0.00							
-----	--	------	--	--	--	--	--	--	--

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA731 Rev: AA & Dwg D3694 Rev: C 2-Tap 10-32 heli-coil holes Manually 2-Deburr per dwg D3694

OK 13/11/11

5 0

120		0.00							
-----	--	------	--	--	--	--	--	--	--

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

OK 13/11/11

5 0

Work Order ID 108991

October-31-13 1:38:48 PM

108991

Page 2

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Accept

N900040100

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Item Name: Mounting Plate

Stop *NS2*

Start Date: 10/30/13 Start Qty: 5.00

5

Cust Item ID:

Required Date: 10/30/13 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

DAS
40
9-89

13/11/12

5

Ø

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

5

Ø

CF 13.11.12

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

150

Powdercoat

Memo

0.00

Powder Coating

*****Mask all in surface as per Dwg

D3694*****START TIME:

3:15 OVEN TEMPERATURE: 520° FINISH
TIME: 3:45

5 Ø

13.11.12

DAS
34
9-89

Work Order ID 108991

October-31-13 1:38:48 PM

108991

Page 3

Item ID: D3694-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Mounting Plate

Start Date: 10/30/13 Start Qty: 5.00 *5*

Cust Item ID:

Required Date: 10/30/13 Req'd Qty: 5.00 *5*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160 QC3- Inspect Part Finish

0.00
SWP
13/11/18

160

QC Memo

170 Identify as per dwg & Stock Location: G.A. 0.00

170

Packaging Memo 0.00

Packaging

180 QC21- Final Inspection - Work Order Release 0.00

180

QC Memo 0.00

Quality Control

S

5

FF
13-11-18

13/11/20

R 13-11-18

Picklist Print

October-31-13 1:38:48 PM

Page 1

Work Order ID: 108991

Parent Item: D3694-1

Parent Item Name: Mounting Plate

Start Date: 10/30/13

Required Date: 10/30/13

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A New Issue 09-01-13 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X06.000 6061T6 BAR 1.00 X 6.00		Purchased	No				f	43.1700		3.032 ⁴		13-11-08	

Location

Loc Qty

Loc Code

MAT003

43.17

m125771

19.17

m126160

12

m126351

12

3.032¹

DART AEROSPACE LTD		Work Order:	108991
Description: Keyway		Part Number:	D3694-1
Inspection Dwg: D3694	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

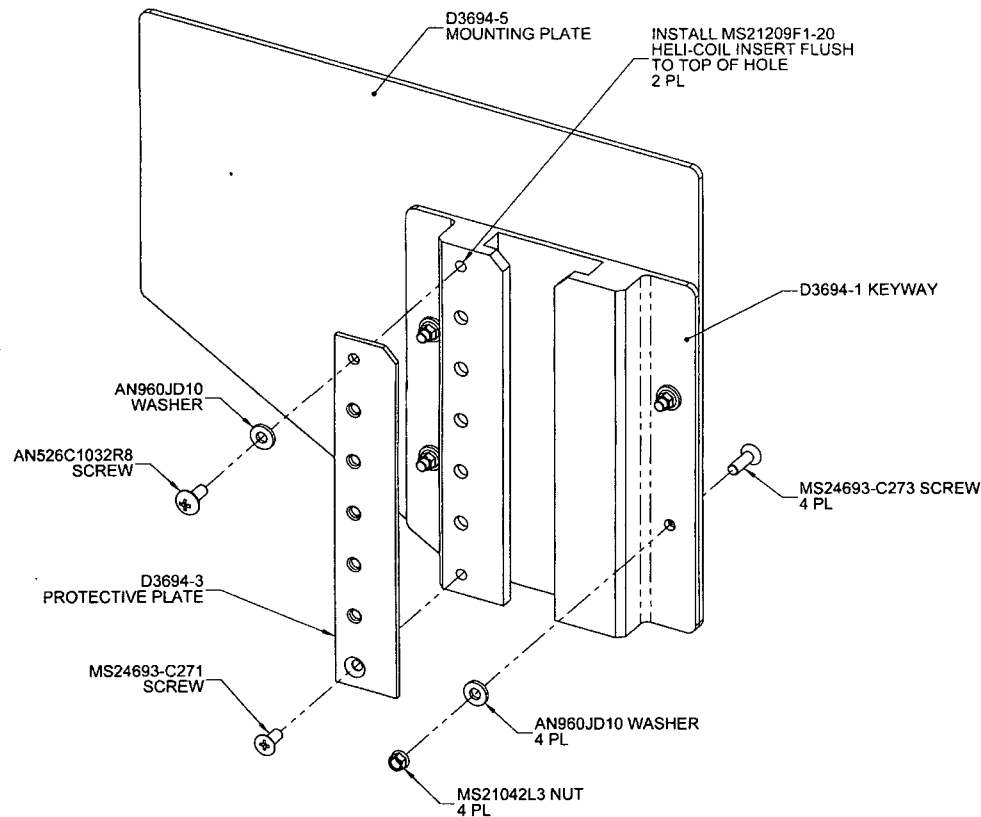
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.201	+0.005/-0.001	Ø.206	✓		Vern	M1-Ø6
0.673 deep	+/-0.010	.673	✓		"	
Ø0.257	+0.006/-0.001	Ø.258	✓		"	
0.200 deep	+/-0.010	.205	✓		"	
6.75	+/-0.030	6.750	✓		"	
6.000	+/-0.010	6.000	✓		"	
4.000	+/-0.010	4.000	✓		"	
1.000 pitch	+/-0.010	1.000	✓		"	
0.375	+/-0.010	.378	✓		"	
4.114	+/-0.010	4.115	✓		"	
1.375	+/-0.010	1.378	✓		"	
2.000	+/-0.010	2.000	✓		"	
2.500	+/-0.010	2.500	✓		"	
Ø0.204	+0.005/-0.001	Ø.207	✓		"	
0.500	+/-0.010	.498	✓		"	
4.602	+/-0.010	4.602	✓		"	
1.000	+0.010/-0.000	1.005	✓		"	
0.13 x 45°	+/-0.030 x 0.5°	.125 x 45°	✓		"	
R0.13	+/-0.030	R.125	✓		R-6	
0.88	+/-0.030	.875	✓		Vern	M1-Ø6
0.125	+0.030/-0.000	.135	✓		"	
5.60	+/-0.030	5.600	✓		"	
3.60	+/-0.030	3.603	✓		"	
2.020	+0.050/-0.000	2.024	✓		"	
0.505	+0.000/-0.005	.503	✓		"	
1.0	+/-0.030	.997	✓		"	
1.791	+/-0.010	1.789	✓		"	
2.301	+/-0.010	2.302	✓		"	

Measured by:	<i>[Signature]</i>
Date:	13/11/11

Audited by:	DAS 40
Date:	13/11/12

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.11	New Issue	KJ	<i>[Signature]</i>



D3694-041 MOUNTING PLATE ASSY

D3694-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3694-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.70 lbs

ITEM	QTY	P/N	DESCRIPTION
1	X	D3694-041	MOUNTING PLATE ASSY
11	1	D3694-1	KEYWAY
12	1	D3694-3	PROTECTIVE PLATE
13	1	D3694-5	MOUNTING PLATE
21	1	AN526C1032R8	SCREW
22	5	AN960JD10	WASHER
23	4	MS21042L3	NUT
24	2	MS21209F1-20	HELI-COIL, SCREW LOCKING (RED)
25	1	MS24693-C271	SCREW
26	4	MS24693-C273	SCREW

C	REDESIGNED ITEM 11; REVISED ITEM 12: DIM Ø0.204 WAS Ø0.234 (ZN D6-3); ADDED ITEM 13; UPDATED BOM TO CURRENT STANDARDS (ZN D3-1); REASON: ENSURE COMPATIBILITY WITH ELIGIBLE OEM AIRCRAFT POSTS AND ELIMINATE SLOPPY FIT.	MB	08.11.03
B	QTY 1 MS24693-C271 SCREW WAS QTY. 2 (ZN D3-1); ADD AN526C1032R8 SCREW AND AN960JD10 WASHER (ZN D3-1, ZN C7-1); 1.18 WAS 1.15 (ZN C7-3); CSK WAS 2 PL (ZN D4-3); 0.810 WAS 0.785 (ZN C3-3). REASON: REDESIGN TO USE AN526 TYPE SCREW HEAD AS SAFETY STOP	MB	08.06.26
A	NEW ISSUE	MB	08.03.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.03		

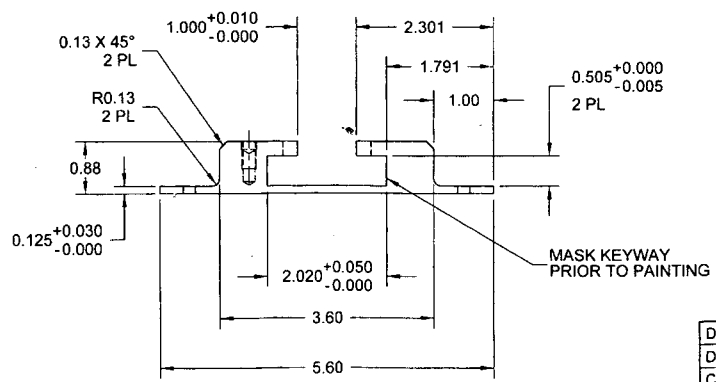
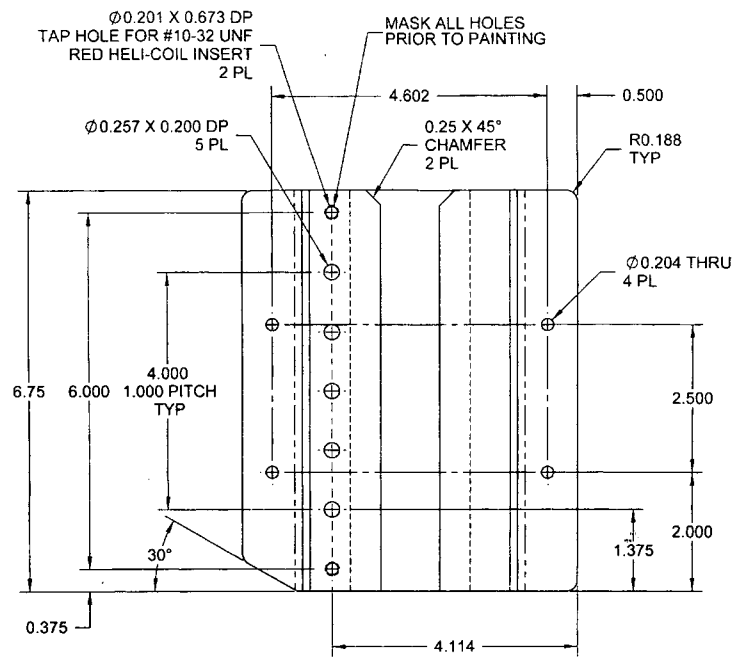
RELEASED
09/12/05 MB

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3694** REV. C
SHEET 1 OF 4
TITLE **MOUNTING PLATE ASSY** SCALE NTS

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
108991



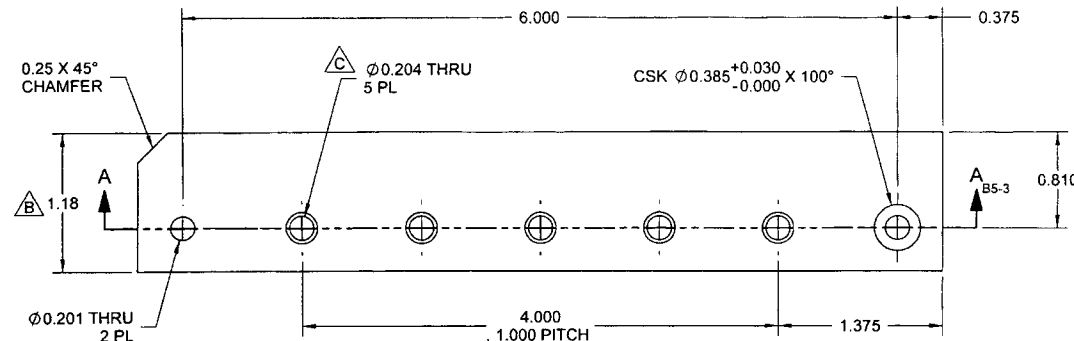
D3694-1 KEYWAY

- D3694-1 NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) REF. DART SPEC. M6061T6B
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.39 lbs

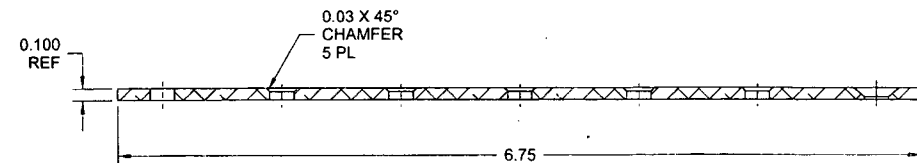
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09/06/05

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3694	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING PLATE ASSY	NTS
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D3694-3 PROTECTIVE PLATE



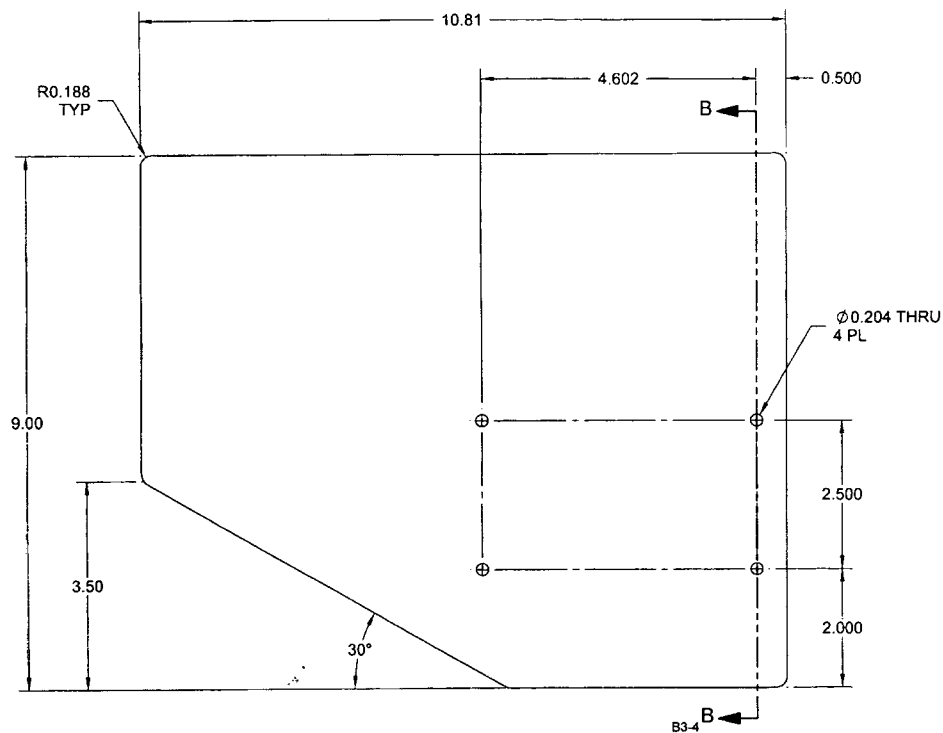
D3694-3 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK),
PER PER AMS 5513 OR AMS 5524
REF. DART SPEC. M304S12GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.22 lbs

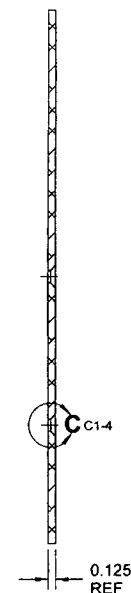
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9/12/05

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MFG. APPR.		D3694	SHEET 3 OF 4
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DE APPR.		MOUNTING PLATE ASSY	NTS
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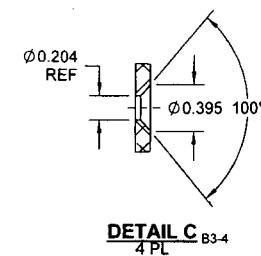
108991



D3694-5 MOUNTING PLATE



SECTION B-B



DETAIL C

RELEASED
09/02/05

- D3694-5 NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR OR AMS 4027
REF. DART SPEC. M6061T6S.125
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.08 lbs

DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO. D3694	REV. C
MFG. APPR.			SHEET 4 OF 4
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